

Date: Thursday, 11/9/2006 4:32:06 PM
User: Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
Job Number : 29377
Estimate Number : 10255
P.O. Number : *N/A*
This Issue : 11/9/2006 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 28902
Part Number : D22301
Drawing Number : D2230 REV F
Project Number : N/A
Drawing Revision : F
Material : *N/A*
Due Date : 11/30/2006 Qty: *225* Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion

Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s) *16.1325*

Lug Extrusion D2423 Extrusion

Batch: *B23779**En oblu12**225*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch: *B23779**En oblu12 / MS oblu11**225*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

*Issue P.O. 2475**Machine per lug D2230 Rev.F**206/11/13 (225)*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Receive + Inspect for tensile**damage**207/01/24 (225)*

5.0 QC5 SECOND CHECK

Comment: SECOND CHECK *Inspect level 5**207/01/24 (225)*

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

218 /mm

COUNTED
07-01-24 (125)

7.0

QC5

INSPECT WORK TO CURRENT STEP



ml 07 01 24



(125)

Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



M103141



(125X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m. 2/4

07/01/25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 7/01/29

(125)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57370

P 7/01/29

(125)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(125)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/30

Job Completion

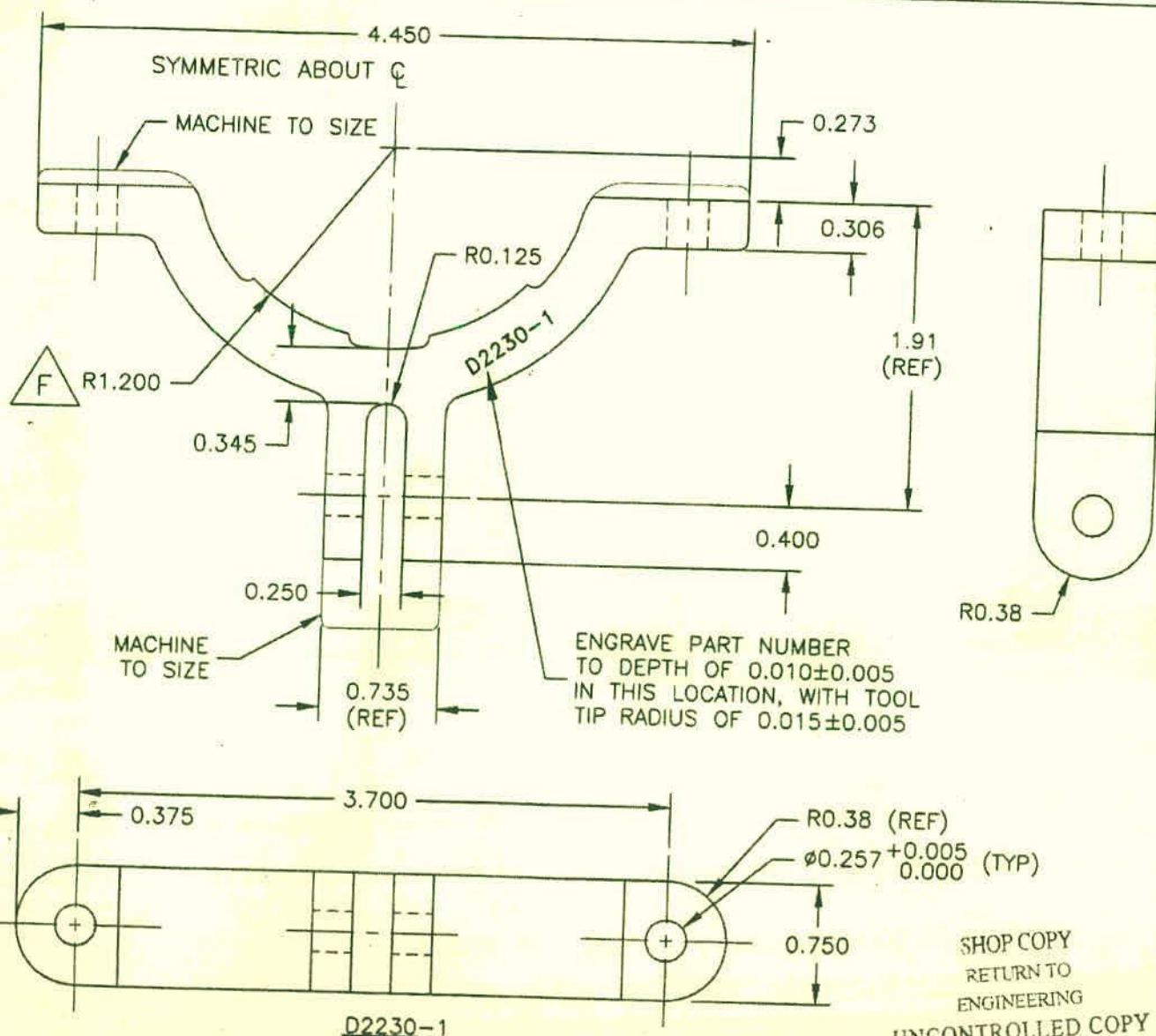


u 07.01.30

counted

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13	TITLE MOUNTING LUG		SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 DS

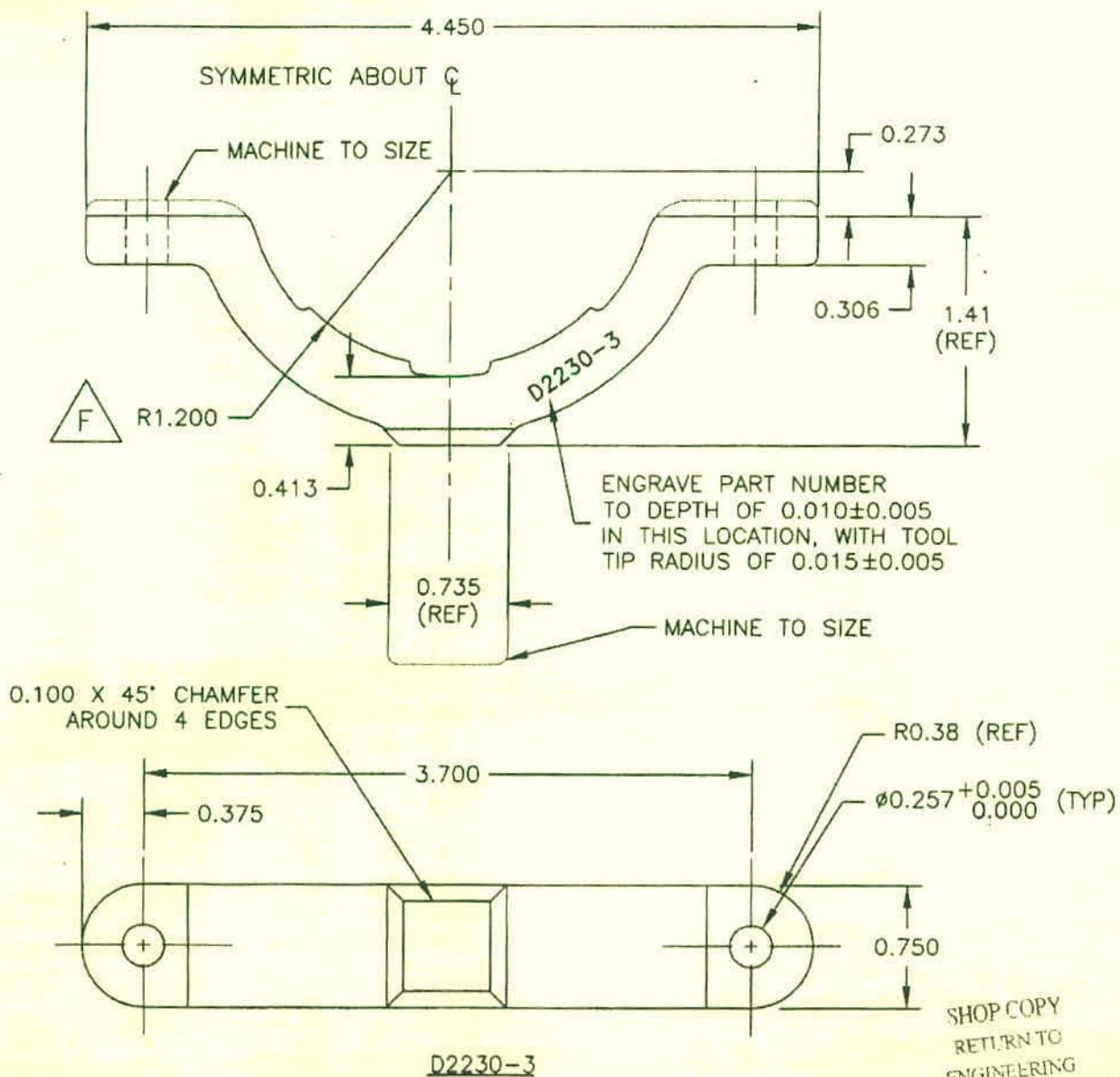
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **29377**



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 29377

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

125

D2230-1

Lug B29377

2475

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Regula Walz
Shigi (Regula) Walz

Vankleek Hill, January 19, 2007

